

Blue

Date: Monday, 17/11/2008 1:53:45 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L FWD X-TUBE
Job Number : 43491	
Estimate Number : 10553	
P.O. Number :	Part Number : D206667103BL
This Issue : 17/11/2008 S.O. No. :	Drawing Number : D206-667-143 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision :
Previous Run : 43472	Material :
Written By :	Due Date : 02/02/2009 Qty: 1 Um: Each
Checked & Approved By : JUD 08.11.17	
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D206-667-103 CHG003		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
3.0	D206667103TRN	Crosstube Turning Detail
Comment: Qty: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) CROSSTUBE TURNING DETAIL batch B 43522		
4.0	BENDING	BENDING MACHINE - SKIDTUBES
Comment: BENDING MACHINE Bend tube as per Dwg D206-667-143 using CNC bender program 206B-fw and Folio FT		
5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes. 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-12-03	4.0 4.1	QC 15 required after bending. Perm change						
		QC 15		08-12-03	1	08-12-03	08-12-03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/01/09

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-02	5.0	Tube is 0.100" lower on side B. R.C. Bend process		Drill cuff 'A' as normal, and cuff 'B' 0.100" lower to even the tube height.	AT 08-12-04	S 08/12/05		

NOTE: Date & initial all entries

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Job Number: 43491

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143.

Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff (Do not engrave on outside of tube)

85
08-12-03

85 08-12-03

6.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



ALM 8-12-05



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1.

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/12/05 (K)

8.0

QC5

INSPECT WORK TO CURRENT STEP



210.7782
08/12/05 0



Comment: INSPECT WORK TO CURRENT STEP.

08/12/05 (K)

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE - CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICE - CROSSTUBES

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

08/12/05 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 43491

Part Number: D206667103BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC6	DIMENSIONAL CHECK
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Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

5 08/12/08 @

12.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 - GREY
B# 110161

ml 08 12 17

2-
-PAINT DELFLEET BLUE B# 11 0077
-CLEAR DELFLEET B# 110161

ml 09/01/05 ①

13.0	QC14	INSPECT SPRAY PAINT
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Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 09-01-06

14.0	D3595075395	RUBBER CUSHION .75" x 3.95
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
RUBBER CUSHION .75" x 3.95

-570 cut
B 37971

RT 09-01-06

15.0	D2873043	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 43176

ml 08 12 17

16.0	D2873045	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 42784

ml 08 12 17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L FWD X-TUBE

Job Number: 43491

Part Number: D206667103BL

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 D28911 2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support 43383

RT 09-01-06

18.0 MS20601AD4W8 RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet 109297

ml 08 12 17

19.0 MS2192020 Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp 109715

RT 09-01-06

20.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Magnabond B 109900

1-Install abrasion strips as per QSI-035 using DT8570. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

RT 09-01-07

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

ml 08 12 17

21.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/01/07 @

22.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D206667103BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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23.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M110363

24.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

25.0	AN57A	Bolt
------	-------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M109752

26.0	AN530A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M109001

27.0	AN960JD516	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109752

28.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

29.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43491

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Per 01/09

31.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

Job Completion



WUF 09-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

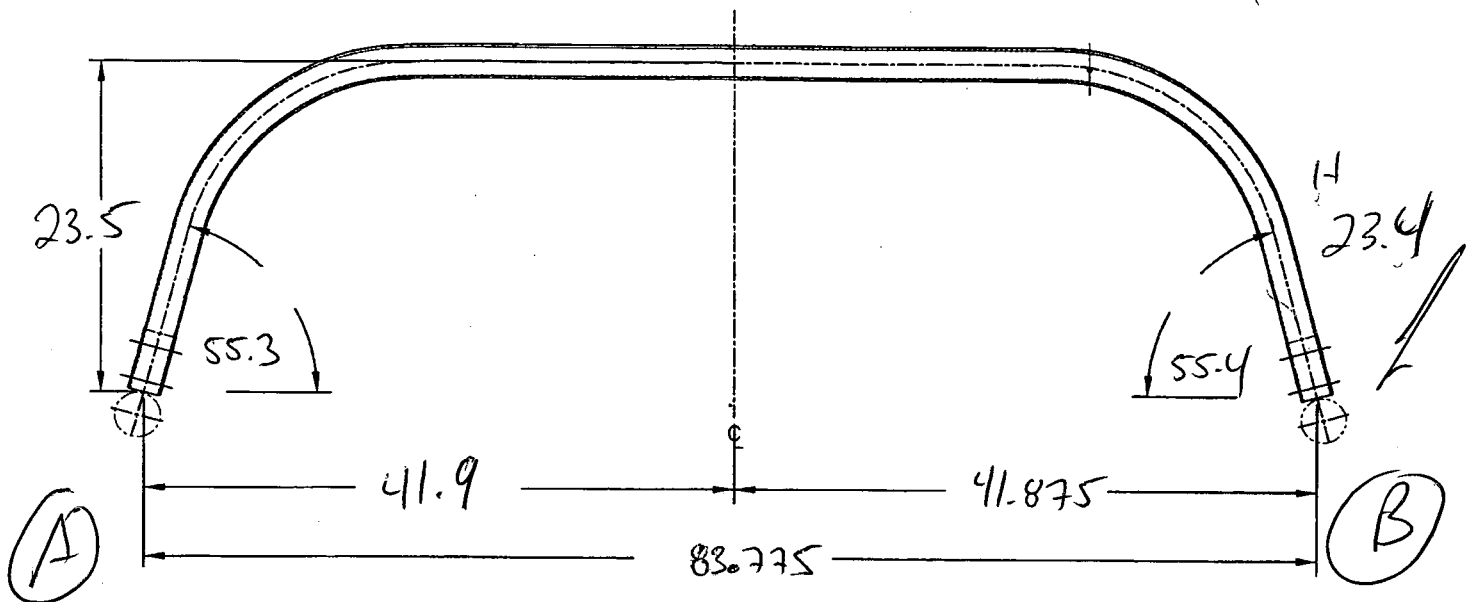
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>H3491</i>
Description: Crosstube High Fwd (206L)		Part Number: D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
Drill cuff 'B' 0.100" lower than A

QC15 Inspection	<i>[Signature]</i>
Date	06/2.02.

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

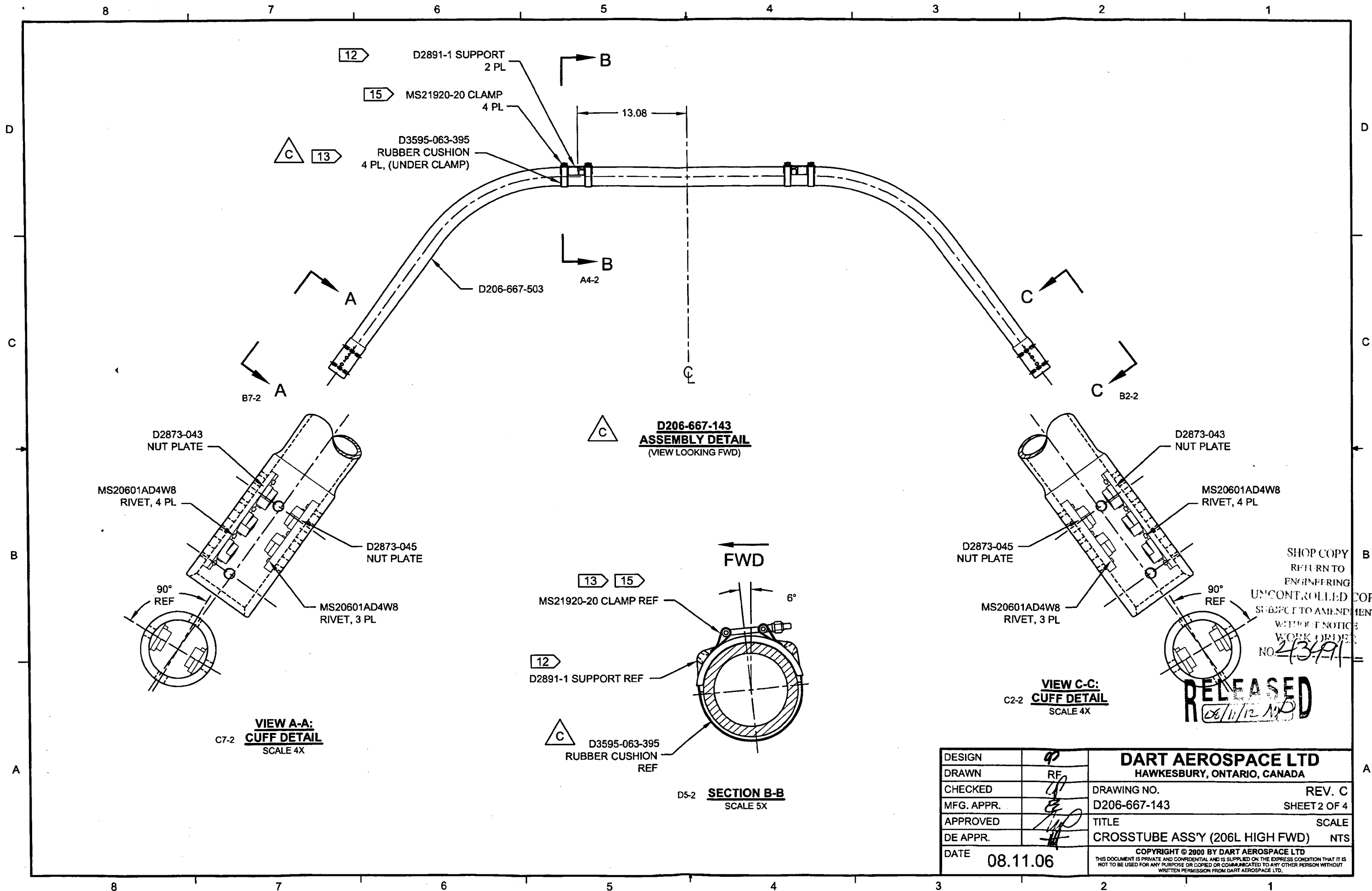
GENERAL NOTES:

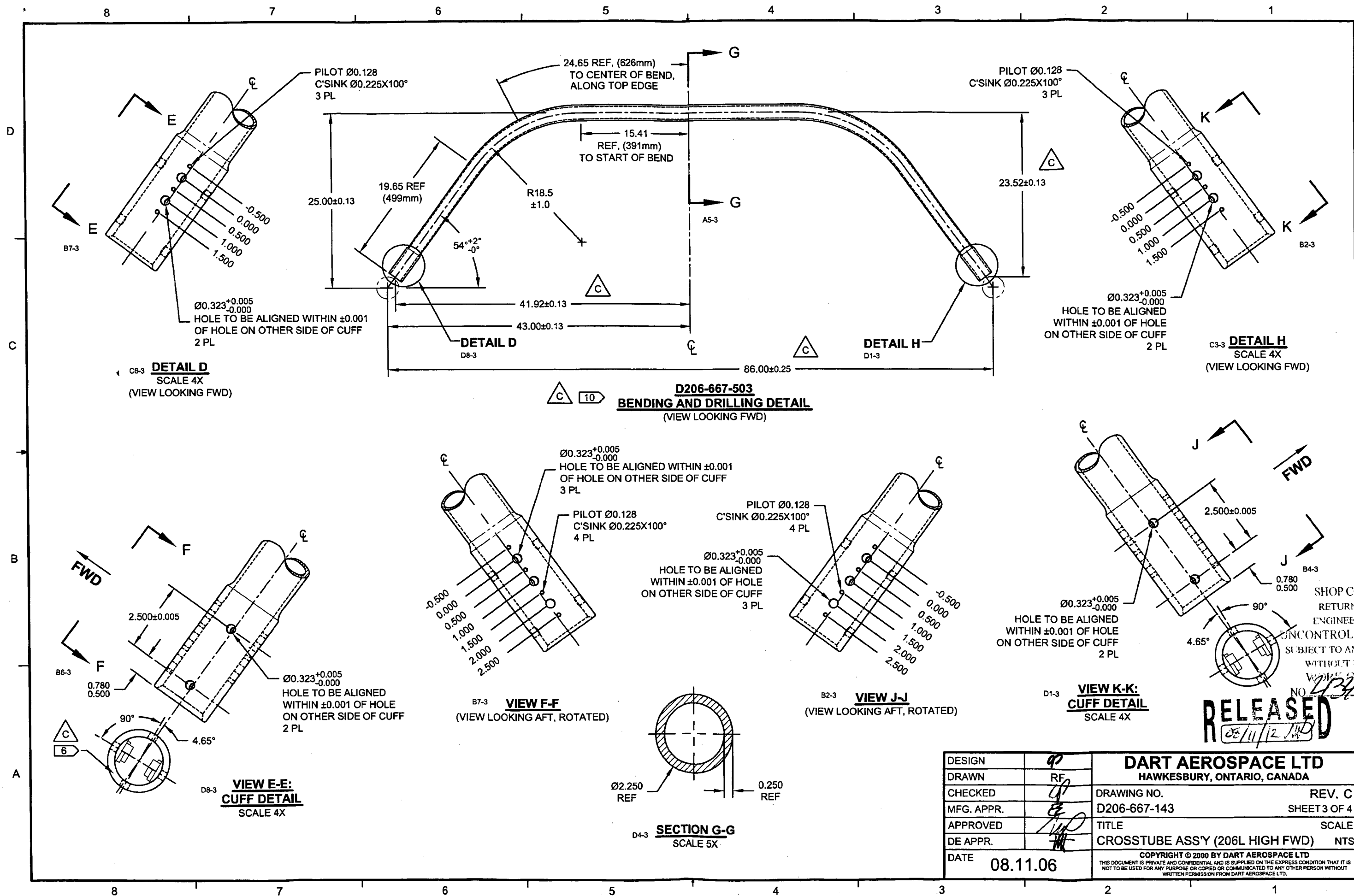
- MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 15.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/10

SHOP COPY
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WORK ORDER
NO 4391

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





D206-667-503
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)

DETAIL D
SCALE 4X
(VIEW LOOKING FWD)

DETAIL H
SCALE 4X
(VIEW LOOKING FWD)

VIEW E-E:
CUFF DETAIL
SCALE 4X

VIEW F-F
(VIEW LOOKING AFT, ROTATED)

VIEW J-J
(VIEW LOOKING AFT, ROTATED)

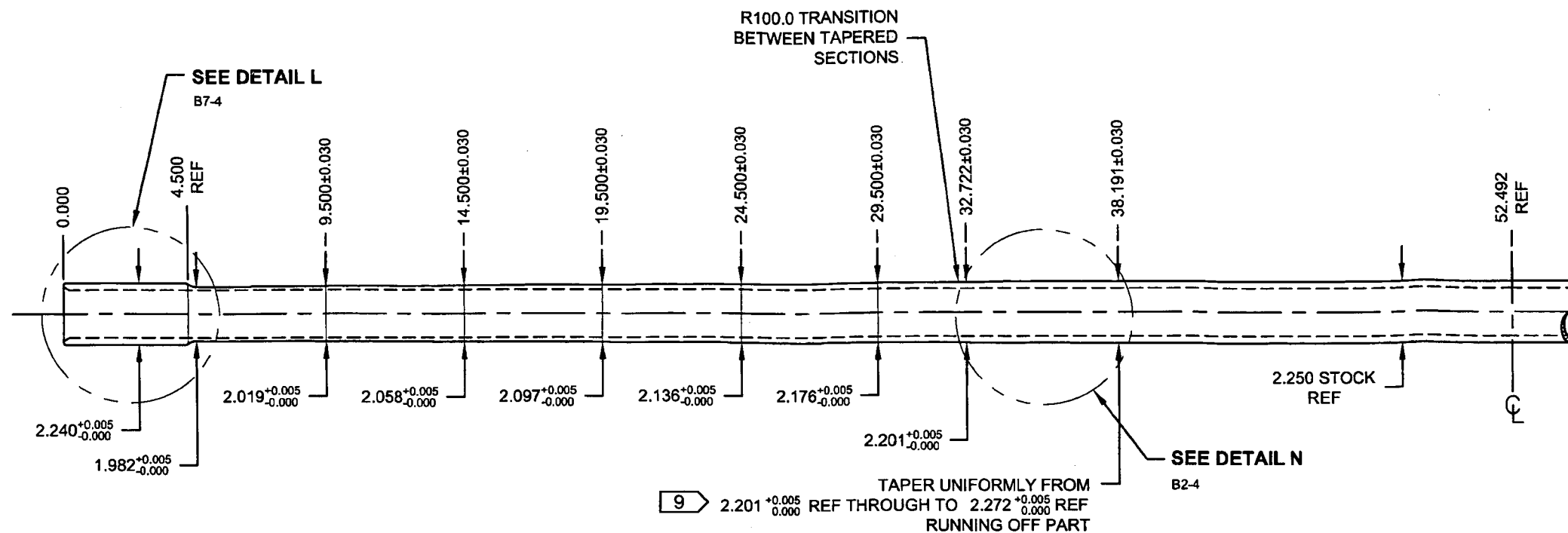
VIEW K-K:
CUFF DETAIL
SCALE 4X

SECTION G-G
SCALE 5X

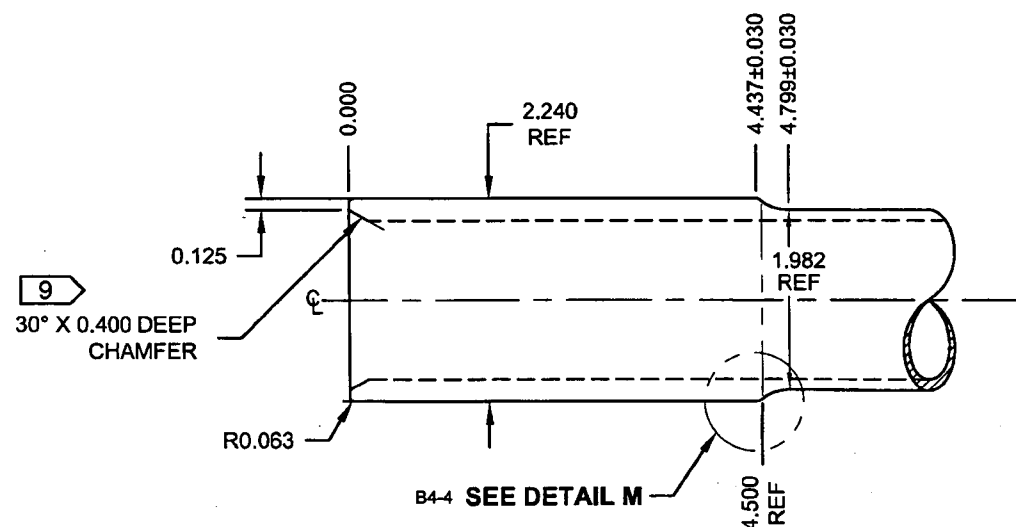
DESIGN	70	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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08/11/12

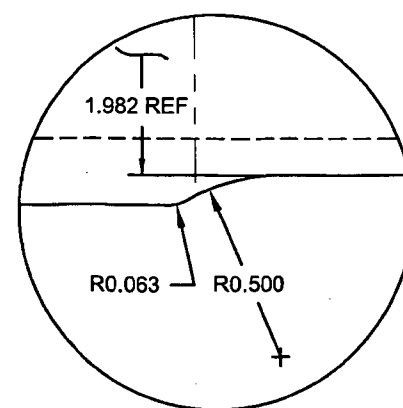
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NO 43891



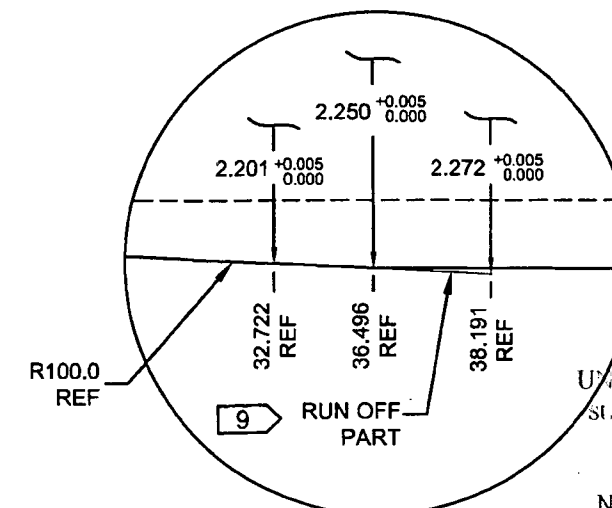
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4 NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A6-4 NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C4-4 NOT TO SCALE

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08/11/06

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D206-667-143	SHEET 4 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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LIQUID PENETRANT TEST REPORT

P- 09133

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Dec 5th 2008 TIME AM ☐ PM ☐
ATTENTION Linda Lacelle ACUREN JOB NO. 188-08-1626
ADDRESS 1270 Aberdeen POWO No. _____
Hawkesbury, Ont. WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417 REV./DATE _____
PROJECT 206L FWD X-TUBE
ITEM(S) EXAMINED Job #'s 43469, 43470, 43471, 43472, 43491, 43492

JOB DESCRIPTION _____ PROCEDURE NO. LT-000 REV./DATE _____ TECHNIQUE NO. LT-000 REV./DATE _____
PART NO. D206667103 BL MATERIAL ALODINE ALUM. THICKNESS _____
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON
100% EXTERNAL SURFACE

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND Magnaflux BLACK LIGHT S/N 0171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT MINIMUM DWELL TIME 30 MIN. LIGHTING EQUIP. ☒ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H₂O MINIMUM DRY TIME >10 MIN. OTHER CAL FEB 09
DEVELOPER SK D52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE _____
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)		ACCEPT	REJECT
ITEM	COMMENTS		
Job #'s 43469:		✓	
43470:		✓	
43471:		✓	
43472:		✓	
43491:		✓	
43492:		✓	
<u>S</u> <u>05/12/08</u>			

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Melanie Fautoux DTR # _____
TECHNICIAN (SIGNATURE): Frederick Chagnon REPORT REVIEWED BY: _____
NAME (PRINT): Frederick Chagnon NAME _____ INITIALS _____
CGSB LEVEL II SNT LEVEL II CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. NO. 10560 CGSB REG. NO. _____

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

File: Wednesday, 19/11/2008 9:03:13 AM
Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FWD X-TUBE
Job Number	: 43491		
Estimate Number	: 10553		
P.O. Number	:	Part Number	: D206667103BL
Issue	: 19/11/2008 S.O. No. :	Drawing Number	: D206-667-143 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 17/11/2008 Type : CROSSTUBES	Drawing Revision	:
Previous Run	: 43472	Material	:
Written By	:	Due Date	: 02/02/2009 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.12.05 c2



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D206667103TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch _____

Job Completion

